NC-36LT PREMIARC™

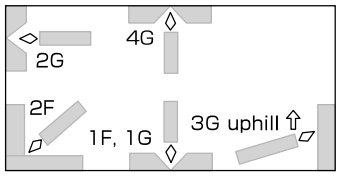
Stick electrode

Features: ▪ Suitable for 18%Cr-12%Ni-2%Mo steel for cryogenic temperature service

Classification: AWS A5.4 E316L-16

Redrying Conditions: 150~200℃x 0.5~1h
Identification color: 1st Green
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	19	300W, 100H, 330L
3.2	350	5	20	34	175W, 110H, 380L
4.0	350	5	20	51	175W, 115H, 380L
5.0	350	5	20	78	175W, 115H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.03	0.04
Si	0.59	1.00
Mn	2.0	0.5~2.5
P	0.03	0.04
S	<0.01	0.03
Ni	13.1	11.0~14.0
Cr	18.0	17.0~20.0
Mo	2.2	2.0~3.0
Cu	0.05	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~130
5.0	135~180	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	390	-
TS (MPa)	530	483min.
El on 4d (%)	44	30min.
IV -196℃ (J)	40	27min.